

Claims

1. Procedure for producing an actuating drive for a fuel injector with a piezoactor (3), piezoactor (3) being movably mounted in a housing (3) and having a baseplate (4) adjoining an opening in the housing (3), characterized in that a presettable excursion of the piezoactor (3) is adjusted by applying an electrical voltage (4) to the piezoactor (2),
5 that the housing (3) in the area of the housing and the base plate (4) are surface ground when electrical voltage (4) is applied.

2. Procedure for producing a compensation collar for an injection valve, characterized in that the compensation collar (9) is inserted between two flat areas and is plastically deformed to a presettable thickness by compressing the two areas together.

3. Procedure according to Claim 2, characterized in that the compensation collar (9) consists of a flowable material, that the material of the compression ring begins to flow during the compression and is thereby permanently plastically deformed.

4. Procedure according to Claim 2 or Claim 3, characterized in that the compensation collar (9) is inserted into a housing (1) of a fuel injector, the compensation collar (9) being arranged in the area of an actuating drive (5, 7) which projects into the opening of the compensation collar (9), that the compensation collar
5 (9) is pressed against the housing with a prestressing device until the prestressing device has moved the actuating drive (5, 7) into a presettable position, the thickness of the compensation collar (9) being reduced.

5. Procedure according to Claim 4, characterized in that the prestressing device in the areas that act on the actuating drive (5, 7) has a boss with a given height (h), that the boss is surrounded by a circumferential edge set back by the given height (h), this edge adjoining the compensation collar (9).

6. Procedure according to Claim 4 or 5, characterized in that the actuating drive (7) is a servo valve, and that the given position corresponds to the opening of the servo valve.

7. Procedure according to Claims 2 through 5, characterized in that the compensation collar (9) is made of soft iron or soft copper.

8. Injection valve with a piezoactor with housing, the piezoactor being movable in the housing and moving out of the housing when triggered and making connection with an actuator, characterized in that between the housing (3) of the piezoactor (2) and the housing (1) of the injection valve, a compensation collar (9) is arranged, the thickness
5 of which has been adjusted by plastic deformation.

9. Injection valve with a piezoactor with housing, the piezoactor being arranged to be movable in the housing and moving out of the housing when triggered and making connection with an actuating drive, that the end of the piezoactor adjoining the actuating drive has a given idle stroke distance from the leading edge of the housing
5 (3), and that the leading edge of the housing (3) is arranged at the level of the actuating drive (5, 7).

10. Procedure according to Claim 1, characterized in that, for surface grinding the housing (3) and the base plate (4) of the piezoactor (2), the piezoactor (2) is clamped into a grinder, electrical voltage (U) being applied to the piezoactor (2) via slip rings.